

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004037**Date Inspected:** 11-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Zhang Bao Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:****Grinding Demonstration**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector observed ZPMC in the OBG assembly bay 2 performing a grinding demonstration on the CJP splice for panels DP66-DP65. ABF representative Peter Shaw was noted as being present during this time and had relayed to this QA inspector that he had marked the 200 mm location for ZPMC to perform this demonstration. ZPMC had started this process at approximately 1500 hours and by the end of this QA inspectors shift had not completed the grinding.

NDT Request

This QA inspector received request for Ultrasonic Examination (UT) verification in the OBG assembly shop bay 2 for segment 3AW. The request number from ZPMC was 1013 for SSD12-PP022, SSD12A-PP022, SSD10A-PP010 and SSD10-PP020. Upon arrival at these locations this QA inspector performed a visual inspection of the requested weldments and determined that the welds were not in conformance with the contract documents. ABF representative Peter Shaw was at this location and was asked to examine the weldments and Mr. Shaw agreed with this QA inspector findings. Mr. Shaw also relayed to the QA inspector that he would write an internal Non-Conformance Report (NCR) to ZPMC for performing UT testing and accepting the weldments prior to these welds being in conformance with visual criteria. This QA inspector did not perform the UT verification due to the weldments not in conformance with the visual criteria prior to UT examination which is outlined in AWS D1.5 of meeting visual inspection prior to performing Non-Destructive Testing.

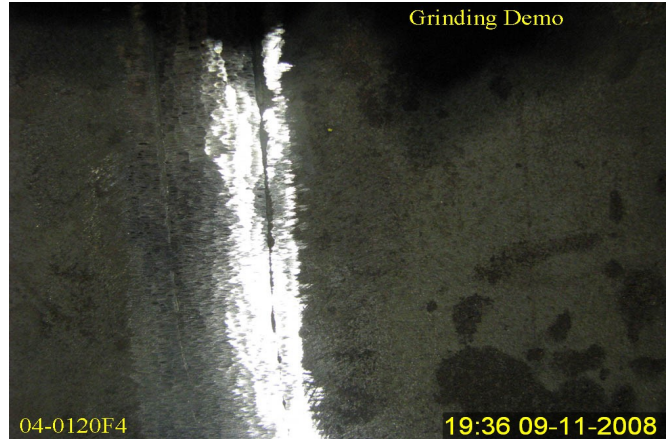
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grinding demo



Grinding Demo



Grinding demo in overhead position



Summary of Conversations:

As stated above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Riley,Ken	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
